DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028089
Date Inspected: 30-Jul-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1930
Location: Job site

CWI Name: Julian Razo

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing (OBG Deck)

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) deck drop-in web/flange connections for lift 13E. The welds have been previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;
Lift 13E Deck Drop-in web to flange Splice (Weld No. 13E-PP121.5-E2.5-BF1)

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were observed at the time of inspection.

The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13E/14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

Magnetic Particle Testing (OBG Lift 13W)

This QA Inspector performed Magnetic Particle Testing (MT) of 100% of the HPS-transverse deck stiffener weld splices designated as 13E-PP122.2-LS1, 13E-PP122.2-LS2 and 13E-PP122.2-LS3. This weld was previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing.

WELDING INSPECTION REPORT

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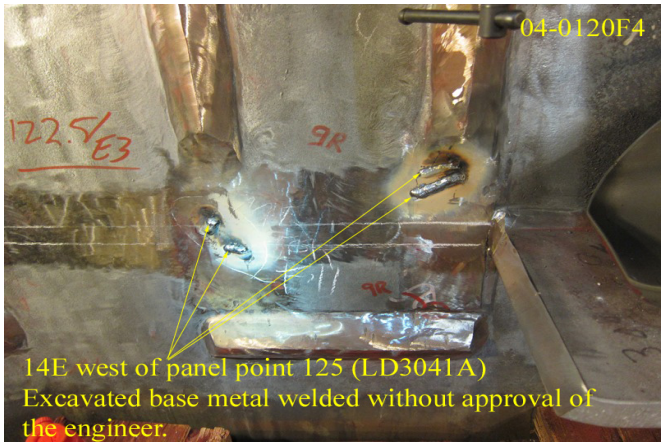
This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

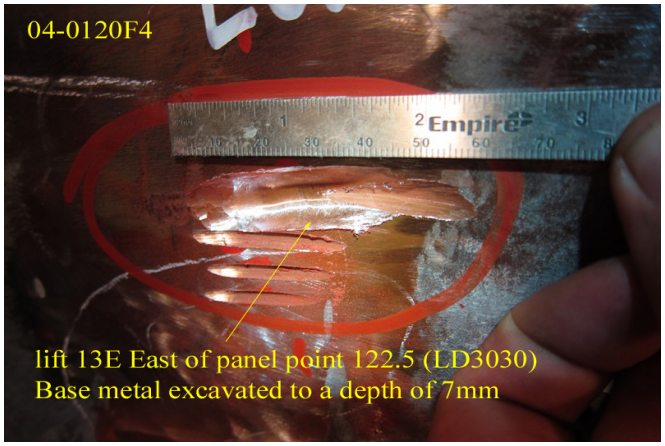
During QA observations of the QC Magnetic Particle Testing (MT) in way of the lifting lug removal areas on the longitudinal diaphragm webs at E3, multiple linear indications were observed. After the removal of the indications by grinding, ABF welding personnel proceeded to weld the excavated base metal without the prior approval of the engineer. The depth of the excavations ranged from 2mm~7mm. The lifting lug removal areas are located at lift 13E East of panel point 122.5 (LD3030) and 14E west of panel point 125 (LD3041A). The longitudinal diaphragm webs, at both locations are designated as Seismic Performance Critical Members (SPCM) on the contract drawings and require through thickness properties (TTP). The QAI's observations were discussed with the QA lead inspector Danny Reyes.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.





Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer